	r ID 74592 · 03, 2011 3:57:39 PM	nsf	P.								Page 1
Item ID: Revision ID: Item Name: Start Date:	D3535-25 Wearshoe 10/3/2011 Start Qty:	12.00			Cust Item			Set	up Star Stop		
Required Date: Reference:	10/5/2011 Req'd Qty:	12.00			Customer:			.	G4-	. 10000000	#110 101 1101 1001
Approvals:	Process Plan:	Date:	1-10-04	Tooling: SPC (Y/N):		ate:		Ru	n Star Stop	1 1 1 1 1 1 1 1 1 1	[]][]
Sequence ID/ Work Center ID	Operation Description		0	Set Up/ Run Hours	Tool ID				Reject -	Reject Number	Insp. Stamp
Draw Nbr	Revision_Nbr										
D3535	Rev B							•			
Waterjet FLOW CNC Waterje			5 □Dwg Rev	0.00 0.00 □Prog Rev:	<u>R</u> =2-		<u>.</u>	1 <u>B11-</u> 11	シケ		5
QC Quality Control		arts off machine FAL	/FAIB	0.00				BII	<u>-10 - 5</u>	- -	Pto-
120	QC8- Inspect pa	arts - second check		0.00	olo 6		/	F17)	(4)		

0.00

Memo

Quality Control

W/O: 74	592		W	ORK ORDER CHANGES				-
DATE	STEP		DURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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_		735-25 PAR #: - HA				. /		1.0.14
1/897		esolution: <u>Scrag</u>	DISPOSIT	DER NON-CONFORMANCE	(NCR)	sed:	k	4(9,1
NCR:		YY	THE ORI		- (14011)	1300 x A	<u> 4 118</u>	1
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section B Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC inspector
Melos	\$\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\	Found Oly xy Parts at with the holes not conting to Day: (see example) R.C. Parts mans Durn water July: Proces		-7 Scrap + Desty aly x4 Replace M 118964	\$ 1.0 \ (1)	1110/06	QSE047 11175/ox	u liolos
		ie =) A A						
NOTE: D	ate & init	al all entries	<u> </u>		<u> </u>			<u> </u>

Work Order ID 74592

Monday, October 03, 2011 3:57:39 PM



Page 2

Item ID:

Revision ID:

Item Name:

D3535-25

Wearshoe

Start Date: Required Date: 10/5/2011

10/3/2011

Start Qty: 12.00 Req'd Qty: 12.00

Accept

Cust Item ID:

Customer:

Tool ID

Run

Setup Start

Stop



Reference:

Approvals:

Process Plan:

Date:

Date: _____

Tooling:

SPC (Y/N):

0.00

Date:____

Date:

Start

Stop



Sequence ID/ Work Center ID

130

Brake NC

Brake NC

Operation Description Set Up/ **Run Hours**

Tool # Plan

Accept. Code **Qty**

Reject ' Oty

Reject Number Stamp

Insp.

NC BRAKE

Memo

Memo

1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261and DT8326□2-Form joggle on Punch as per Dwg D3535 using Jig DT8158Identify as D3535-25

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

150

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

□OVEN TEMPERATURE:

Danfulloft

W/1842N

320F

Dart Ae	rospace	Ltd					,	,	, =
W/O:			W	ORK ORDER CHANGI	ES				
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Part No		PAR #:							
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		Description of NC		Corrective Action Section		Verif	ication	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Sec	ction C	Chief Eng	QC Inspector
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Work Order ID 74592

Monday, October 03, 2011 3:57:39 PM



Page 3

Item ID:

D3535-25

Accept

Setup Start

Stop



Revision ID:

Item Name:

Wearshoe

Start Date: 10/3/2011 Required Date: 10/5/2011

Start Qty: 12.00

Req'd Qty: 12.00

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop



Sequence ID/ **Work Center ID**

160

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

1.70

Packaging Packaging

Identify as per dwg & Stock Location

Memo

0.00

0.00

180

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

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		-							

Picklist Print

Monday, October 03, 2011 3:57:55 PM

Work Order ID: 74592

Parent Item:

D3535-25

Parent Item Name: Wearshoe



Start Date: 10/3/2011

Required Date: 10/5/2011

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A New Issue 07-02-15 JLM

IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	170.5795	0.51	6.442105	311-10-	5	
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DATE	STEP	Section A	Initial Chief Eng	Action Descrip Chief Eng	tion ————	Sign & Date		ion C	Chief Eng	QC Inspector

DART AEROSPACE LTD	Work Order:	74598
Description: Wearshoe	Part Number:	D3535-25
Inspection Dwg: D3535 Rev: B	,	Page 1 of 1

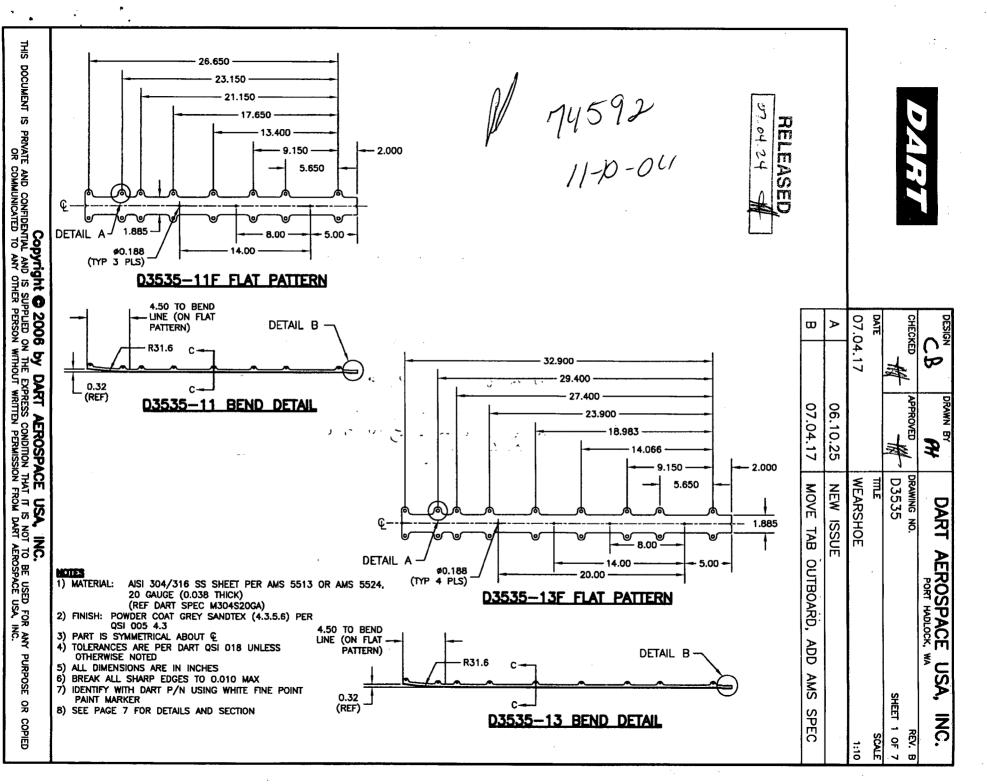
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16.350	+/-0.010	16.350	0	-	7		
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12.750	+/-0.010	12.750	~		+		
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Rev Date	Change				Revised	by	Approved
A 07.11.23	New Issue				KJ/EC/D		N

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Dart Aerospace Ltd

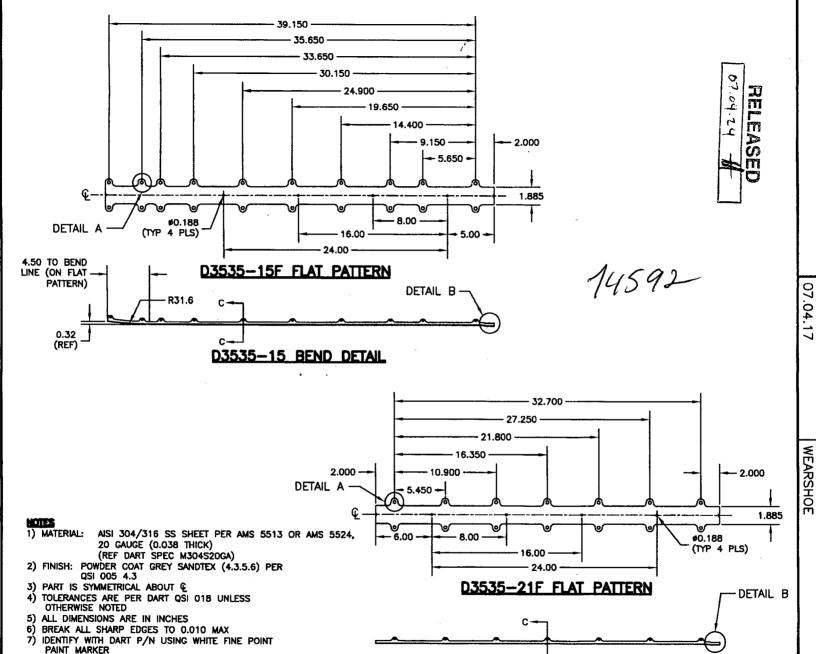
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D3535-21 BEND DETAIL

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8) SEE PAGE 7 FOR DETAILS AND SECTION

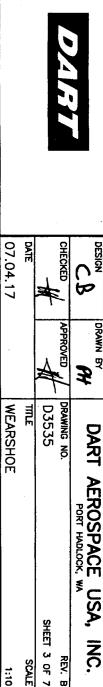
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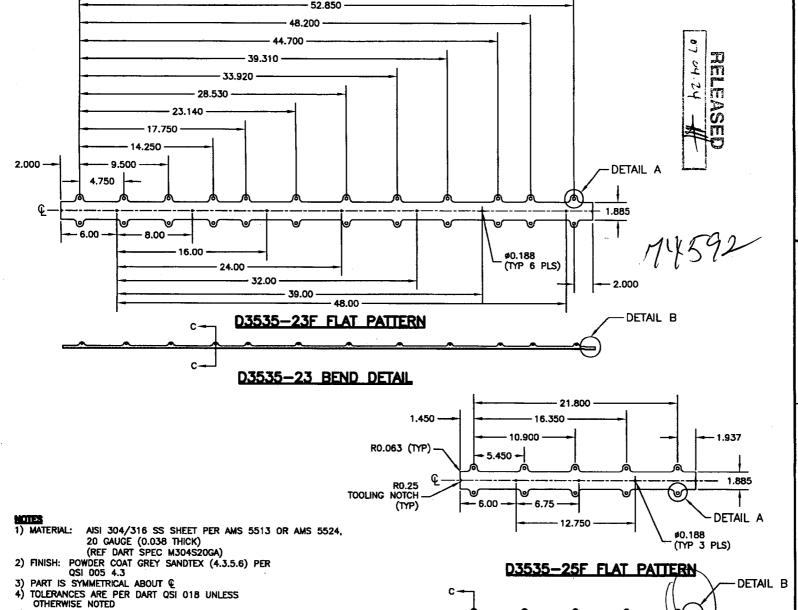
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D3535-25 BEND DETA

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PURPOSE

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5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES TO 0.010 MAX

8) SEE PAGE 7 FOR DETAILS AND SECTION

PAINT MARKER

7) IDENTIFY WITH DART P/N USING WHITE FINE POINT

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANG	ES		,, ,,,,, = .	
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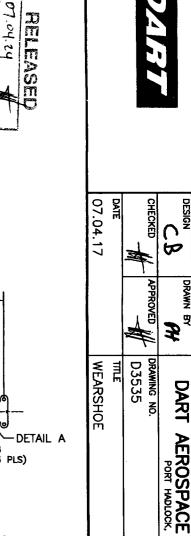
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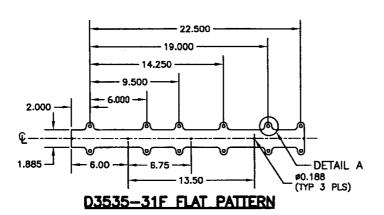
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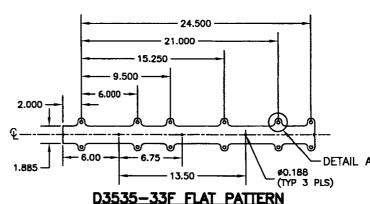
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SCALE 1:10









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AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA) 1) MATERIAL:

2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

3) PART IS SYMMETRICAL ABOUT &

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES BREAK ALL SHARP EDGES TO 0.010 MAX

IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER

8) SEE PAGE 7 FOR DETAILS AND SECTION



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CHECKED

APPROVED

DRAWING NO.

D3535

WEARSHOE

1:10

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3

DART

AEROSPACE (

USA,

₹C.

DATE 07.04.17

to 15 6 RELEASE POS

D3535-35F FLAT PATTERN

#0.188

(TYP 2 PLS)

DETAIL A

14.250

4.750

2.000

1.885

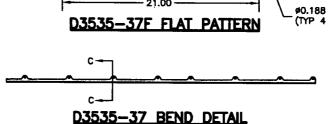
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D3535-35 BEND DETAIL

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D3535-37F FLAT PATTERN (TYP 4 PLS)	

1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

- 3) PART IS SYMMETRICAL ABOUT ©
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



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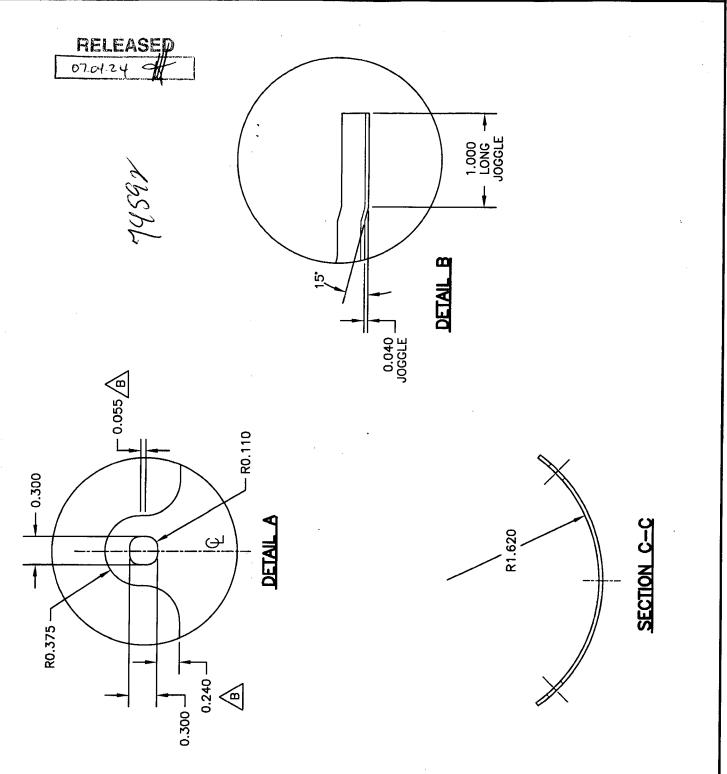
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		D3535	SHEET 7 OF 7
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